

Date: Tuesday, 4/18/2006 10:07:04 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 26691		
Estimate Number	: 10424		
P.O. Number	: N/A	Part Number	: D33031
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3303 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 22107	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 5/20/2006
Checked & Approved By	: <u>06.04.18</u>	Qty:	8 Um: Each
Comment	: Est:A 04.06.07 New issue KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.3719 sf(s)/Unit Total: 2.9753 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.032" thick
 (M2024T3S.032) Batch: M12758

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 9.200" x 5.050"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA460 and Dwg D3303
 Identify as D3303-1

M 06 05 11

(8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 11

(8)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

0605-13 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 20/05/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:04 AM
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Drawing Name: PLATE

Job Number: 26691

Part Number: D33031

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SAD 06:05:16 8

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-17 (8)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06:05:21 8

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06-05-23 (8)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST422

06/05/24 (8)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/05 (8)

Job Completion



C206165125

Dart Aerospace Ltd



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

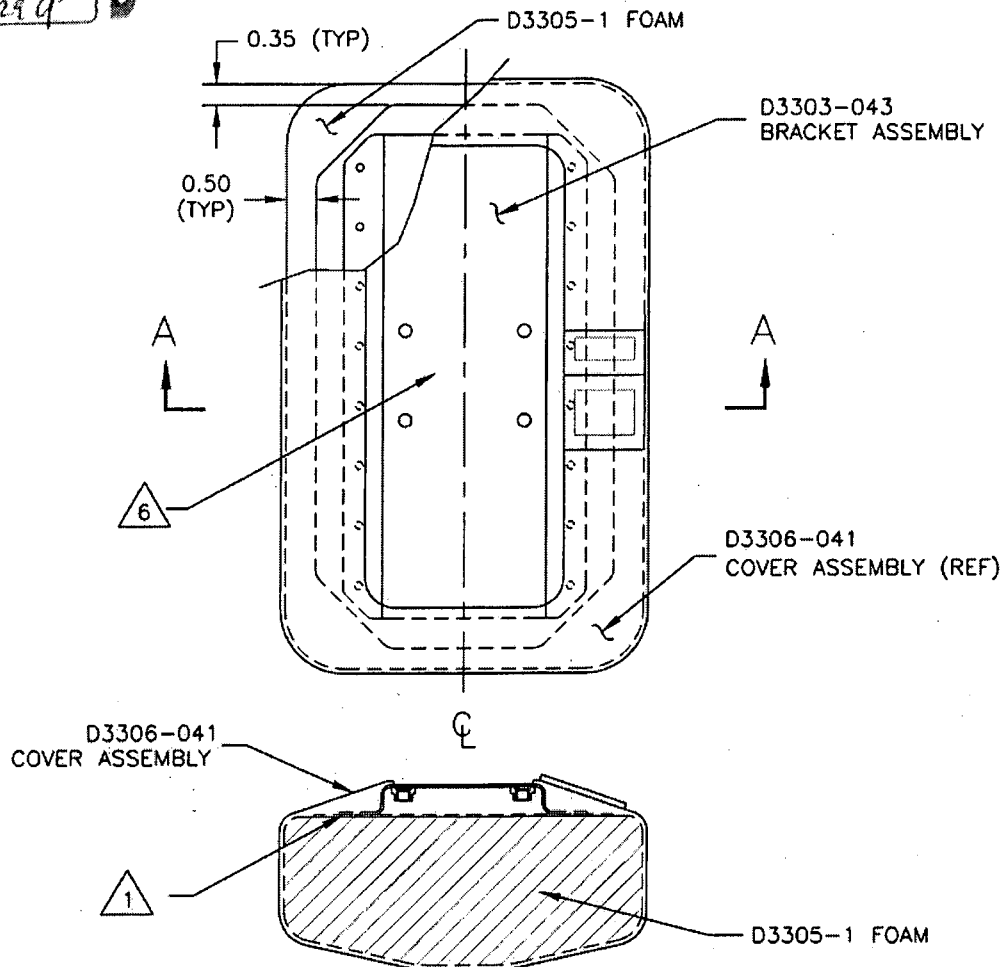
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.29 6'**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

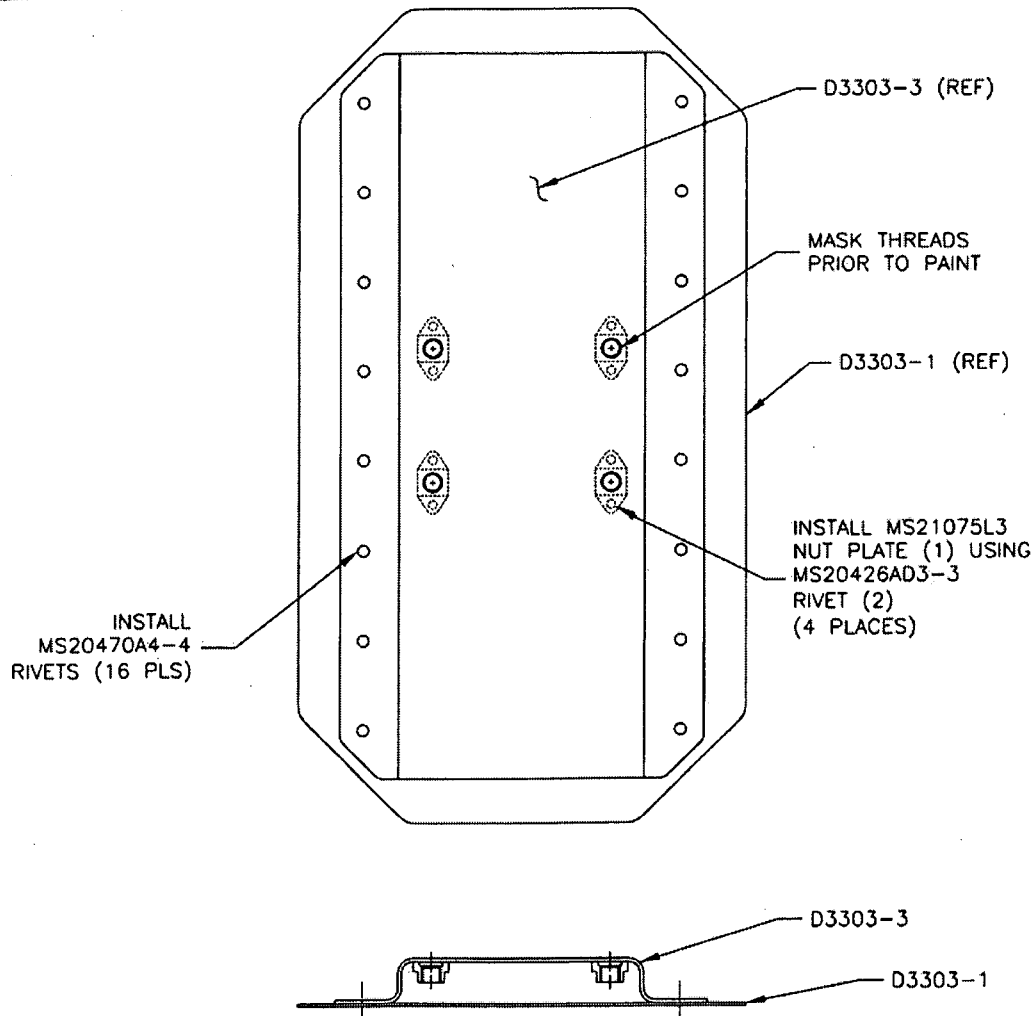
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

RELEASED
04.09.29 CP**D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

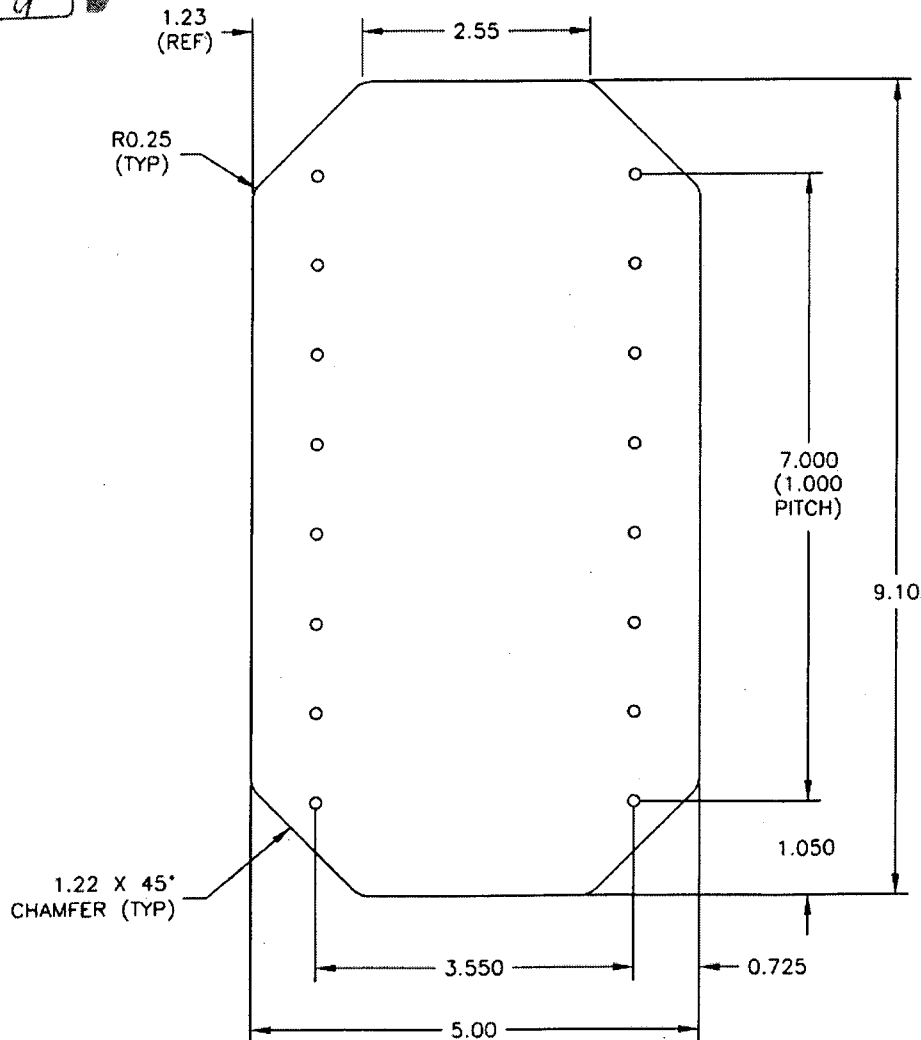
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

RELEASED
04.09.29 UP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S-032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

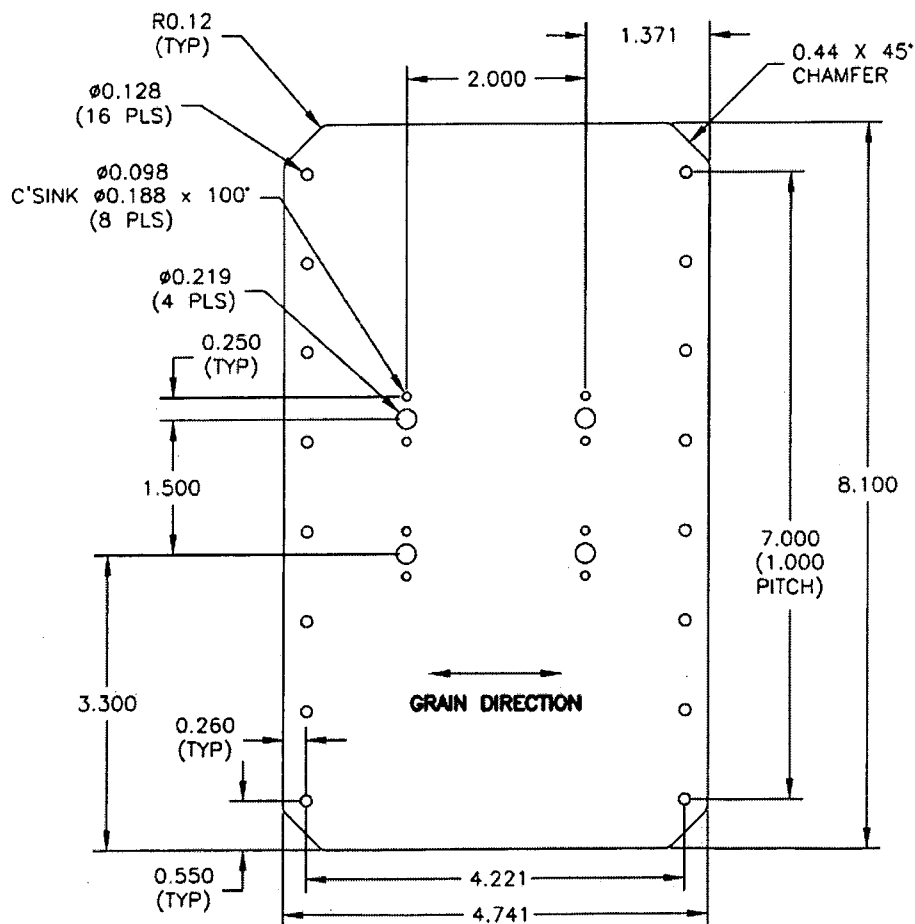
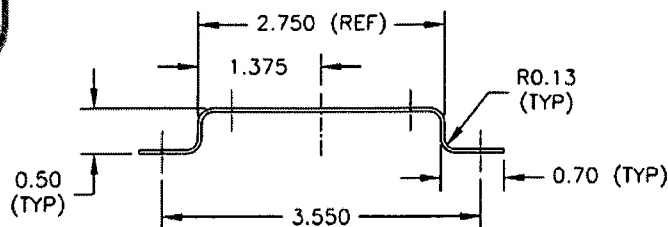
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CHECKED H	APPROVED H	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**
04.09.29 CP**D3303-3 BRACKET
BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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